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EVOLUTION OF THE COLLAR.

A Great Industry that Grew Out of a Frenchman's Idea—How Collars are Made by the Million.

Half a century since dandies were gotten up to kill at a hundred yards with their necks swathed in, first, soft and high standing collar, that reached its points quite to the ears, and over that a glossy satin or lambskin band stiffened with brocade and fastened around the wearer's neck by strings tied behind. This latter item of gorgoness was somewhat a gathering of apoplectic tendency, which was nothing more than a generous silk handkerchief carefully folded, wrapped around the collar and terminating in a graceful knot.

The collars worn there were all the productions of the domestic shirtmaker, and were usually part and parcel of the shirt. Collars were unknown, except as applied to outer garments, and that indispensable appendage to the shirt-sleeve which we know by the name had reached no greater stage of development than is conveyed by their primitive name of "wristbands." They were also attached to the shirt. The American trade in separable collars or bars and cuffs dates from the year 1834, when a worldly Methodist parson of Troy, N. Y., Ebenezer Brown by name, shocked his good neighbors by manufacturing a dozen or so and peddling them about from a hand basket. The scheme must have been a partial success. It at least started a small trade, which slumbered along in different hands for a good ten years, when the time had come for some one to arouse it and send the present industry breathing through time.

Each of the many very estimable firms engaged in this branch of trade has fixed up a little family tree to prove that he was the grandfather of one of their members, thus clearly showing themselves to be the original Troy collar men.

For many years there were but a few standard "slims" or "stays," and those common to all manufacturers and branded alike. Every man who made a "Shakespeare," a "Bishop" or a "Senate" called it by the common name and competed only in regard to the quantity he could sell. Now every maker has a dozen different styles to name (generally with classical terms) and copyright to himself twice a year; although down at the bottom his shapes are just as much like those of another maker as in the old days.

The linen or muslin used in the manufacture of collars and cuffs varies from ordinary to very fine. Among the leading manufacturers celebrated for the excellence of their goods, only the finest Irish linen is used. In many cases it is made especially to their order and for their use. Manufacturers who sell at extremely low figures cannot afford to use the upper grade linens, and therefore purchase and use the cheaper article.

The linen is delivered to the manufacturers in pieces of about sixty yards each. The exact grade is carefully ascertained in the collar factories by counting the number of threads to an inch in the fabric, which is done with a specially constructed combination of magnifying glass and sealed measure. The threads vary from "fifteen hundred" to "twenty-three hundred," according to fineness, but the usual counts are from "twenty" to "twenty-two hundred" for collar and cuff manufacture.

Muslin used in the process for inner layers and backings is counted in much the same way, but from seventy-eight to eighty-two is considered uniformly good for the purpose. The goods are cut to measure by hand from a series of maple-wood patterns with a sharp steel blade. Due allowance is given in this work for the stitching and shrinkage which is to finally reduce the collar to its standard make.

The linen "facings" are then "interlined" with the requisite phys of muslin, two interlinings thus making a four-ply collar of the finished article, though for cut four interlinings are generally the rule. In standing collars both back and front facings are of linen, in turn-down only the outer, the concealed facing being of fine quality muslin. When the several pieces of the collars are thus laid together in dozens they are taken to another department, where the inner side of the back is branded with name, trademarks and side with indelible ink, and then each set of pieces is firmly pasted together, inside out, with a strong starch paste. They are then sewed tightly together along the outer edges and sent outside to be turned by another class of operatives altogether. These collar turners are deft-fingered earners of pin-money, and do all this work at home, sending for and returning the material to the factory. Turndown collars require two turnings of the sewed material—one for the cap and one for the band—which parts are stitched together ultimately. Standup collars necessarily need only one turning. Button holes are punched in the proper places as a mere slit in the goods, and quickly bound on a special sewing machine. A second punch is then employed, which raises the stitching in the form of a narrow rim with a neat round cleft hole at the top.

The finest buttonholes are hand-worked throughout, but it is by no means necessary to their serviceability. The finished collars are then laundered according to the "Troy" method, in big blunder drums holding hundreds at a time, and ironed by passing them through a series of heated steel rollers, which give a high gloss and finish. Modern styles in collars are entirely matters of shape and dimensions, changeable on some half dozen standard forms. Among these are the height of the collar from base to top and the space allowed between the ends in front.

All the stylish collars of to-day are modifications of the oldest models, and time advances manufacturers go further back for their patterns instead of forward. The "Garrolo" is the simplest and most original form of standup collar. It was once a simple strip of reinforced linen without grace and beauty.

As shirts began to be cut low it was necessary to cut away part of the back so as to make it conform to the slant of the neck band toward the front. Then some one conceived the idea of showing the throat, and to that end cut away all of the front except the fit to take necessary for buttonholes. That move gave this appearance to the collar, and left it to warn days and human nature to bend the ends thereof down into what we are pleased to think is a triumph of our later civilization—the bust point collar. Everybody appears to have turned out to add their individual hurrahs of welcome to the Executive and the charming young wife who accompanies him. Early this morning the rain, which began falling yesterday, continued but with phenomenal good luck, a few minutes before ten o'clock when the carriages reached the Kimball to escort the President for a drive through the city and to the capitol, it grew considerably brighter. The rain ceased, and the clouds continued threatening. Upon reaching the State Capitol the President was received by the Governor and staff and members of each branch of the Legislature. He also met the visiting Governors, members of the Supreme Court, superior and city courts, judges, United States officials and other dignitaries.

SYSTEMATIC HIGHWAY ROBBERY.
How a Big Chicago Firm Crushes Out their Sewing Girls Lives.

(From the Chicago Inter-Ocean.) A few belongings of this small family were nicely stored away in the one room, and three motherless children began the struggle for self-maintenance. The little ones could do nothing, so the responsibility rested upon the shoulders of the 14-year-old sister.

The first thing she did after the funeral was to scan the papers for advertisements in the "help wanted" columns. She found in an evening paper an advertisement for a girl to run a knitting machine. It was from a well known firm on a prominent street. She applied and was given a job. After she had been restored, the exercises of the were opened by President Collier's announcement that prayor would be offered by the Rev. Dr. Barnett, of the First Presbyterian Church. After prayer Mr. Collier presented Mr. H. W. Grady, who delivered a very eloquent address of welcome.

Mr. Grady said: "My countrymen, I shall have the honor of introducing to you to-day the foremost ruler of this earth, the President of the American people; one to whom, by the peaceful and unquestioned suffrages of these people, their highest commission has been given. [Great applause.] It is the most sacred political trust that can be entrusted to modern statesmanship. Our profound pleasure, sir, in welcoming you to-day in emphasized by the knowledge that you have held that high commission with dignified sincerity, and that you have honored this high office with a strong and spotless administration. [Great applause.] As for this exposition, it is enough to say that a law suit is pending for the growing cotton crop of this season, planted seventy days ago in the season, for want of rain, and the machinery of the machine and steam power.

She was credited with 20 cents apiece for two jackets (that's 40 cents) and 30 cents for the dozen bustles (that's 70 cents). She was charged 45 cents a day for the use of machine and steam power (that's 90 cents), leaving a balance of 20 cents due the big firm. At this rate she would have to pay her rent at the end of a week to pay the firm for the bad air she breathed while using the machine and steam power.

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